

Work Order ID 144824

144824

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Monday, April 25, 2016 2:19:18 PM

Item ID: D3580-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Joggle Bracket

Stop *NS2*

Start Date: 4/26/2016 Start Qty: 30.00

30 60 SA
30 60

Cust Item ID:

Required Date: 5/3/2016 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan: MCS Date: APR 25 2016

Run Start *NR1*

QC: _____ Date: _____ Tooling: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3580	C

100 0.00

100

FLOW WATER JET

Waterjet

Memo

0.90

FLOW CNC Waterjet

1-Cut as per Dwg
Dwg Rev: C
Prog Rev: C
2-Deburr if necessary

(60)

Dec 16/04/27

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.60

Quality Control

(60)

Dec 16/04/27

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.60

Quality Control

(60)

DAS
38
9-89
APR 28 2016

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Item ID: D3580-1

Accept

N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Joggle Bracket

Start Date: 4/26/2016 Start Qty: 30.00

30

Cust Item ID:

Required Date: 5/3/2016 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.10							
130	Small Fab				DAS				
Small Fab	Memo	0.60			30				
Small Fab	Bend as per dwg D3580 using 1/8" offset die				9-89				MAY 09 2016
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.60							
Quality Control									DAS 38 9-89 MAY 09 2016
150		0.00							
150	Identify as per dwg & Stock Location: <u>5043</u>								
Packaging	Memo	0.30							
Packaging									60 DAS 0 9-89 MAY 09 2016

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Setup Start *NS1*

Stop *NS2*

Customer:

Run Start *NR1*

Stop *NR2*

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

3.00

Memo

MLJ

~~MAY 10 2016~~

MLJ MAY 09 2016

Picklist Print

Monday, April 25, 2016 2:19:22 PM

Work Order ID: 144824

144824

Parent Item: D3580-1

D3580-1

Parent Item Name: Joggle Bracket

Start Date: 4/26/2016

Required Date: 5/3/2016

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev :A New Issue 07.06.25 EC
IPP Rev:B Removed Powder Coat 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	387.4482	0.009	0.284211			

M304S18GA

304/316 .050 Sheet

04/16/04/27

Location

Loc Qty

Loc Code

MAT020

166.096

M133328

112.496

M133587

53.6

MAT20

128

M134580

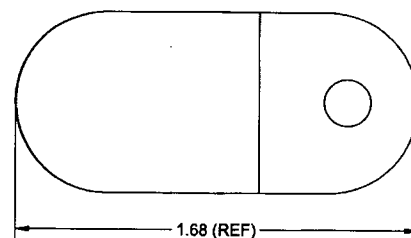
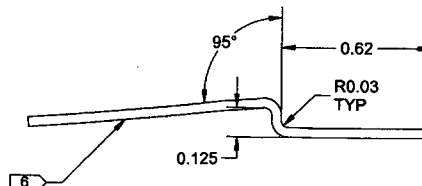
128

TPI

93.3522

M134604

93.3522



D3580-1 JOGGLE BRACKET

STANDARD
REF TO
ENCLOSURE
UNCONTROLLED COPY
SUBJECT TO CONFIDENTIALITY NOTICE
WHEN ORDERED

144824 MJS
1604-25

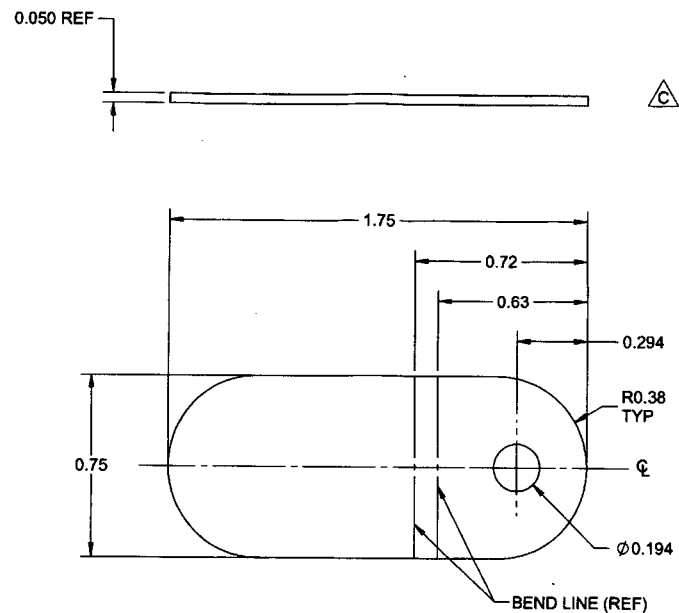
RELEASED
2014-07-02

NOTES:

- 1) MATERIAL: MADE FROM D3580-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON THE UNDERSIDE OF THE PART AS INDICATED
- 7) WEIGHT: 0.01 lbs

C	UPDATED DWG FORMAT, ADDED D3580-3 (ZN B5-3) AND D3580-5 (ZN B5-4). ADDED SIDE VIEW TO D3580-1F (ZN D5-2)	AK	14.02.12
B	REMOVE POWDER COAT	CB	07.07.09
A	NEW ISSUE	CB	07.05.15
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO. D3580	
MFG. APPR.	JLM	REV. C	
APPROVED	HS	TITLE JOGGLE BRACKET	
DE APPR.	DS	SCALE NTS	
DATE	14.02.12	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



D3580-1F FLAT PATTERN

RELEASED
2014-07-02
WHP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
(REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

APPROVED

DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3580	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	JOGGLE BRACKET	NTS
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